

**Work Order ID 69715**

Tuesday, May 17, 2011 3:31:08 PM



Page 1

Item ID: D3282-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Web (206L/407)

Start Date: 5/17/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: MWDate: 11-05-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3282

Rev C

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut to length as per Dwg D3282.  
2- inspect for surface damage as per QSI0018  
3- Deburr

&gt; DP

11-5-17

6

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA579 & Dwg D3282  
2-Deburr

B.A 11/08/03

6

φ

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 11/08/03

6

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69715**

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Item ID: D3282-041

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11/08/08

6

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11-08-08

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

11-8-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 69715

Tuesday, May 17, 2011 3:31:08 PM



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Item ID: D3282-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Web (206L/407)

Start Date: 5/17/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web A/RN/ALPS-3 <u>m11655c</u>								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
180 	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
Packaging	Memo	0.00							
Packaging									

SAD 11-08-09

J.uloslos

Bu/08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69715**

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Item ID: D3282-041

Accept



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Item Name: Float Web (206L/407)

Start Date: 5/17/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/09

MF  
11-08-09

# Picklist Print

Tuesday, May 17, 2011 3:31:03 PM

Page 1

Work Order ID: 69715

Parent Item: D3282-041

Parent Item Name: Float Web (206L/407)




Start Date: 5/17/2011

Required Date: 5/31/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:B 05.09.23 Procedure change KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2792-130  EXTRUSION		Manufactured	No			160	Each	30.0000	1	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				HALL		30							
				61630		30							
D3283-1  Doubler		Manufactured	No			160	Each	55.0000	2	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST045		29							
				66947		29							
				ST048		26							
				66553		26							
MS20470AD4-7  Rivet, Universal Head		Purchased	No			100	Each	1,872.000	57	342			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST320		1872							
				116081		572							
				117423		1300							

⑥ 11-5-17

342 11-08-09

12

340 11-08-09

342



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	6975
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282	Rev: C	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

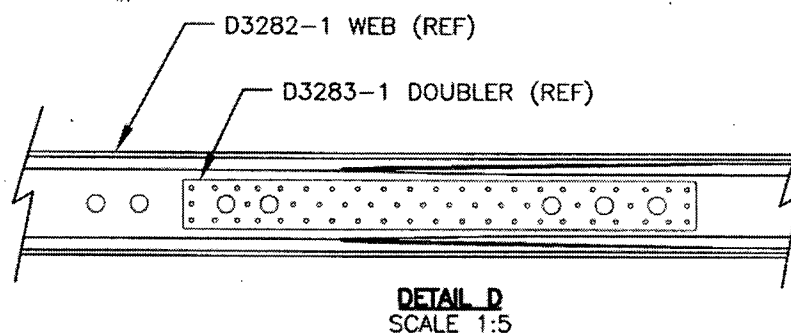
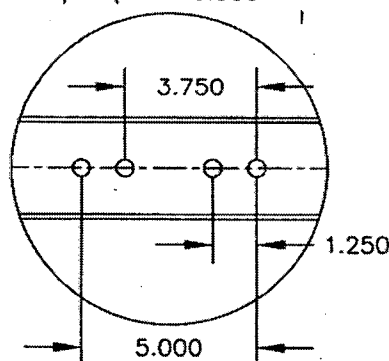
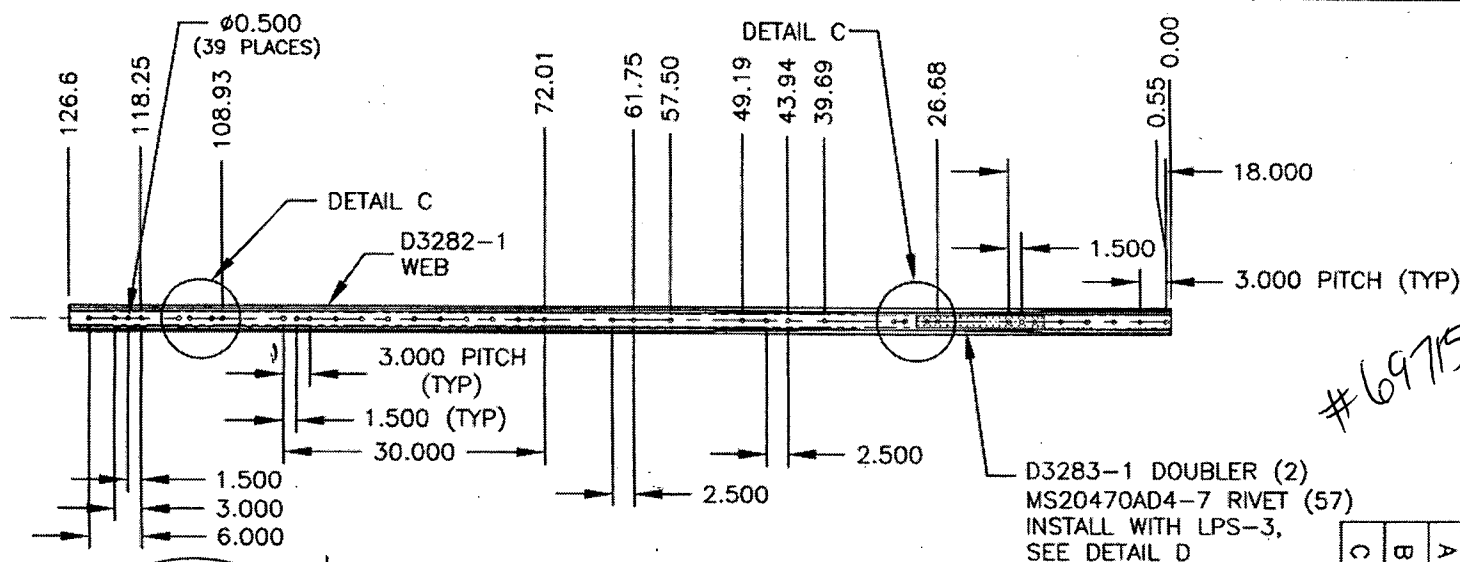
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.600	✓		Tape	GA-12
1.500	+/-0.010	1.500	✓		Vern	GA-01
3.000	+/-0.010	3.000	✓		"	"
6.000	+/-0.010	6.000	✓		"	"
1.250	+/-0.010	1.250	✓		"	"
30.000	+/-0.010	30.000	✓		Tape	GA-12
1.500	+/-0.010	1.500	✓		Vern	GA-01
72.01	+/-0.030	72.010	✓		Tape	GA-12
61.75	+/-0.030	61.750	✓		"	"
57.50	+/-0.030	57.500	✓		"	"
49.19	+/-0.030	49.190	✓		"	"
43.94	+/-0.030	43.940	✓		"	"
39.69	+/-0.030	39.690	✓		"	"
26.68	+/-0.030	26.680	✓		"	"
0.55	+/-0.030	0.551	✓		Vern	GA-01
1.970	+/-0.010	1.972	✓		"	"
2.38	+/-0.030	2.385	✓		"	"
0.05	+/-0.030	0.051	✓		Dial	HAAS-1

Measured by: B.A.	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11/08/03	Date: 11/08/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	[Signature]



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CP	CP	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. C	
#	#	D3282	SHEET 1 OF 2	
DATE		TITLE	SCALE	
05.08.09		Float WEB, 206L/407	1:20	
A	04.05.05	NEW ISSUE		
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS		
C	05.08.09	REMOVE D3390-1, NOW MACHINED		





#### D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

RELEASED

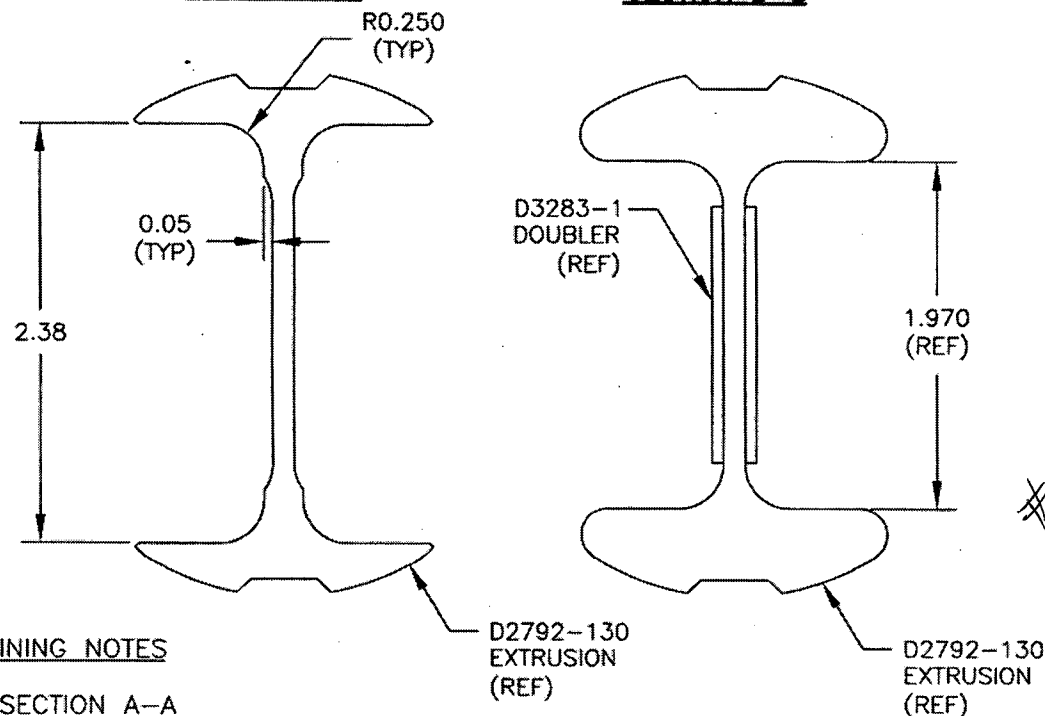
05.09.12

#69715

DESIGN	CP	WORKING SET	CP	DARI AEROSPACE USA, INC.	
CHECKED				APPROVED	DRAWING NO.
				D3282	SHEET 2 OF 2
DATE				TITLE	
05.08.09				FLOAT WEB, 206L/407	
				REV. C	SCALE
					1:20

RELEASED  
05-04-12

**SECTION A-A**



(REF)

1 UNIFORM SECTION A-A

2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B

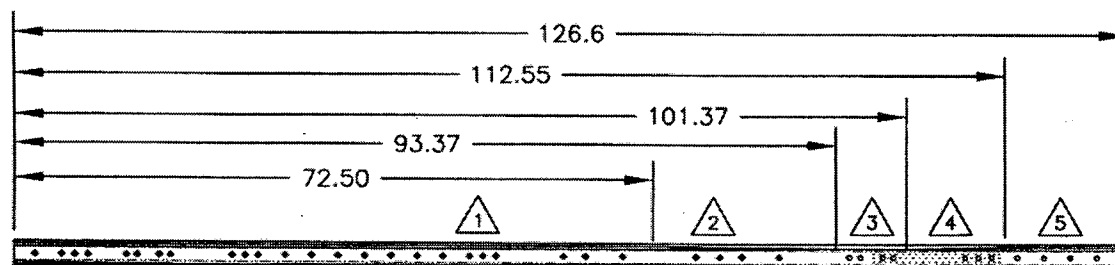
3 UNIFORM SECTION B-B

UNIFORM TAPER FROM SECTION B-B TO SECTION A-A

4 DRILL #30 ( $\phi 0.128$  REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,  
SEE DETAIL D FOR REFERENCE

5 UNIFORM SECTION A-A

6 R1.00 BETWEEN SECTIONS



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